

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	HANDLE WELDMENT
Job Number	40211			
Estimate Number	10333			
P.O. Number	:		Part Number	D2530
This Issue	03/07/2008	S.O. No. :	Drawing Number	D2530 REV B
Prsht Rev.	NC		Project Number	N/A
First Issue	11	Type : SMALL /MED FAB	Drawing Revision	B
Previous Run	37853		Material	:
Written By	:		Due Date	10/07/2008
Checked & Approved By	JMF 08-07-03		Qty:	19
Comment	Est Rev:E	Removed Purchasing	05-11-07	JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W
		<p>Comment: Qty.: 3.0602 f(s)/Unit Total : 61.2045 f(s) Material: 304/316 SS Seamless Tubing 0.75" OD x 0.049" wall(M304TR0.750W.049) Batch: M1084998</p>
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		<p>Comment: SMALL & MEDIUM FAB RESOURCE 1</p> <p>1-Cut to length as per Dwg D2536</p> <p>2-Deburr</p>
3.0	QC5	INSPECT WORK TO CURRENT STEP
		<p>Comment: INSPECT WORK TO CURRENT STEP</p>
4.0	D2534	Lock Plate
		<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s) Pick: B37919 → 32 QTY Part # Description Batch B32620 → 5 2 D2534 Lock Plate B36662 → 1</p>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		<p>Comment: SMALL & MEDIUM FAB RESOURCE 1</p> <p>1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301</p>

W/I/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
8/7/14	# 50	only enough D2534 to make 19 D2530. Put one (1) D2536 in stock with B# 40211	JS	08/07/14 (M)	U	S 8/8/14	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 03/07/2008 10:37:38 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 40211

Part Number: D2530

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Deburr

6.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

MF 08/07/14

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/14 A

8.0 POWDER COATING

POWDER COATING



M 102316

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 2:00pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 2:30pm

08-07-14

X 19

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 08/07/14

10X

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 204

AS 08/07/15 A

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/16 A

Job Completion



MF 08-07-16

DART

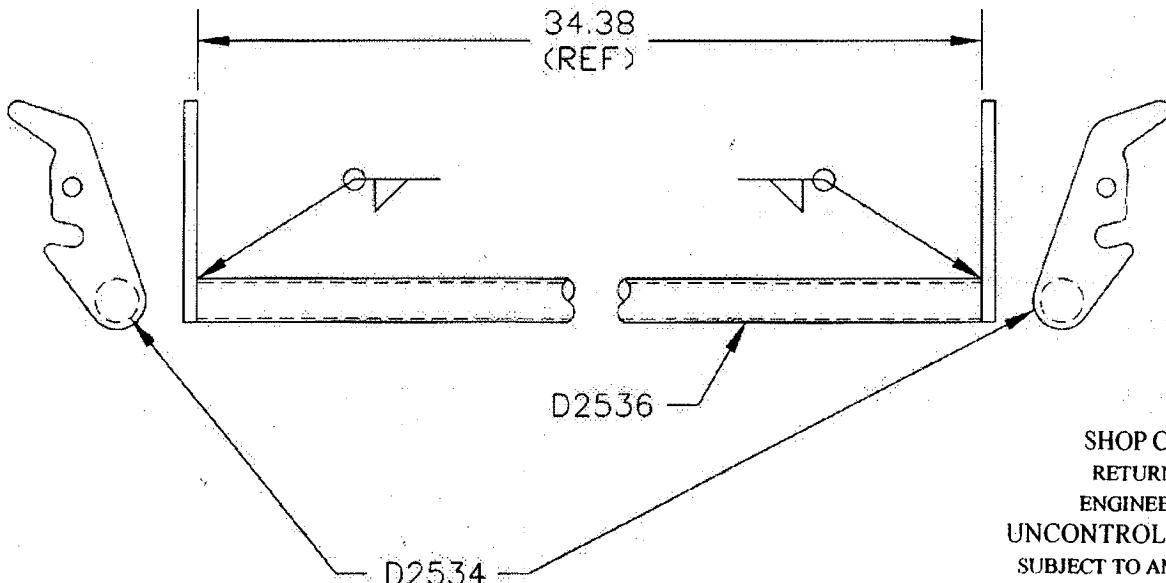
DESIGN B. WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2530	REV. B SHEET 1 OF 1
DATE 04.12.14	TITLE HANDLE WELDMENT		SCALE
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

RELEASED

04.12.16

PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40211

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED